

675.012

Dart Aerospace Ltd.

Date: Tuesday, 06/05/2008 8:57:29 AM
 User: Julie Lecocq

Process Sheet

| | | | |
|----------------------------------|---------------------------------------|-------------------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : A119 STEP WELDMENT RH |
| Job Number | : 39068A | | |
| Estimate Number | : 10130 | | |
| P.O. Number | : | Part Number | : D3043042 |
| This Issue | : 06/05/2008 S.O. No. : | Drawing Number | : D3043 REV A |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : / / Type : LARGE FAB ASSY | Drawing Revision | : A |
| Previous Run | : 36579A | Material | : |
| Written By | : | Due Date | : 30/05/2008 Qty: 5 Um: Each |
| Checked & Approved By | JUD 08.5.06 | | |
| Comment | : Est Rev :A New Issue JLM 05-11-01 | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-----------|----------------|
| 1.0 | D2622120C | Step Extrusion |
|-----|-----------|----------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: D2622-120C extrusion

Batch: 337784

PL 08.05.06

5

| | | |
|-----|-------------|------------------------------|
| 2.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 120.00" long as per Dwg D3043 using cutting table setup DT8185-G

2-Deburr and bevel ends for welding

PL 08.05.07
PL 08.05.07

5

5

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

PL 08.05.07

| | | |
|-----|-------|----------------|
| 4.0 | D2734 | Step End Plate |
|-----|-------|----------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2734 End Cap

336520

PL 08.05.08

5

| | | |
|-----|--------|--------------|
| 5.0 | D30401 | Mounting Lug |
|-----|--------|--------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3040-1 Mounting Lug

333896

PL 08.05.08

5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Tuesday, 06/05/2008 8:57:29 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT RH

Job Number: 39068A

Part Number: D3043042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D30403

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3040-3 Mounting Lug

335976

PE 08.05.08 5

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld 1 End Cap & Mounting Lugs as per QSI 004 & Dwg D3043 Using DT8808

AR AL ROD Batch:

M106834
M107678

2-Grind Fwd End Cap weld flush

PE 08.05.08 5
PE 08.05.09 5

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08.05.12 (5)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/12 (XSRM)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

FL/BR 08/05/12 (5)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-1-Weld 1 End Cap as per QSI 004 & Dwg D3043

AR AL ROD Batch:

M106834

2-Inspect for foreign object as per QSI 024

PE 08.05.13 5
PE 08.05.13 5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT RH

Job Number: 39068A

Part Number: D3043042

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Grind Fwd End Cap weld flush

FL 08-05-13 5

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-05-14 (S)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/05/14 (5RN)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Touch up Chemical Conversion Coat as per QSI 005 4.1

FL 08/05/14 (S)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect alodine

M-L 08/05/14 (SX)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

8:11 AM

OVEN TEMPERATURE:

320 °F

FINISH TIME:

2:41

M-L 08/05/15

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Wing Walk as per Dwg D3043 and QSI 005 4.4

M-L 08/05/15

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/5/16

SC (SX)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: A119 STEP WELDMENT RH

Job Number: 39068A

Part Number: D3043042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



(5x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ADP 39068

8/5/22

SP

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/23

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-22

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



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|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3043 | REV. A SHEET 1 OF 2 |
| DATE 01.06.28 | | TITLE A119 STEP WELDMENT | SCALE NTS |
| A | 01.06.28 | NEW ISSUE | |

PARTS LIST:

| Qty -041 | Qty -043 | Part Number | Description |
|-------------|-------------|-------------|-------------------|
| X | | D3043-041 | STEP WELDMENT, LH |
| | X | D3043-042 | STEP WELDMENT, RH |
| | | | |
| 1 | 1 | D2622-120 | STEP EXTRUSION |
| 2 | 2 | D3040-1 | MOUNTING LUG |
| 2 | 2 | D3040-3 | MOUNTING LUG |
| 2 | 2 | D2734 | ENDPLATE |
| | | | |

NOTES:

- 1) MANUFACTURE FROM D2622-120 EXTRUSION
- 2) WELD PER DART QSI 004. ALL WELDS SHOULD BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004
- 3) FINISH: ACID ETCH & ALODINE ASSEMBLY PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT TOP SURFACE OF STEP TO BOTTOM OF TOP
RADIUS PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
01.07.05 *[Signature]*

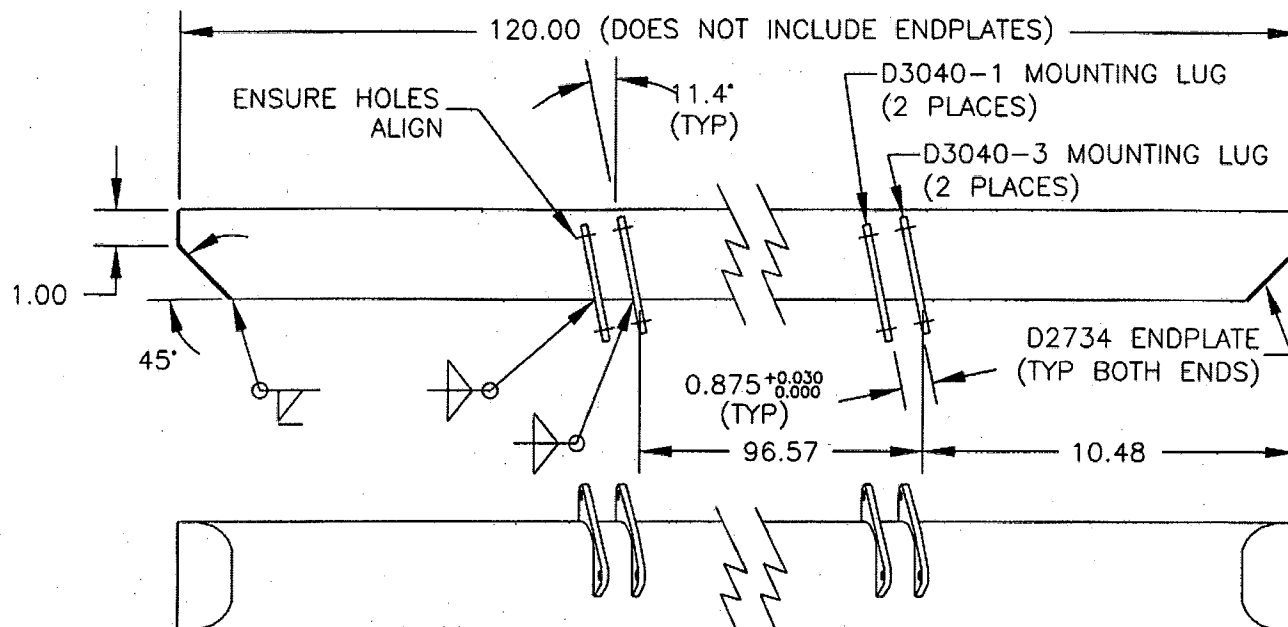
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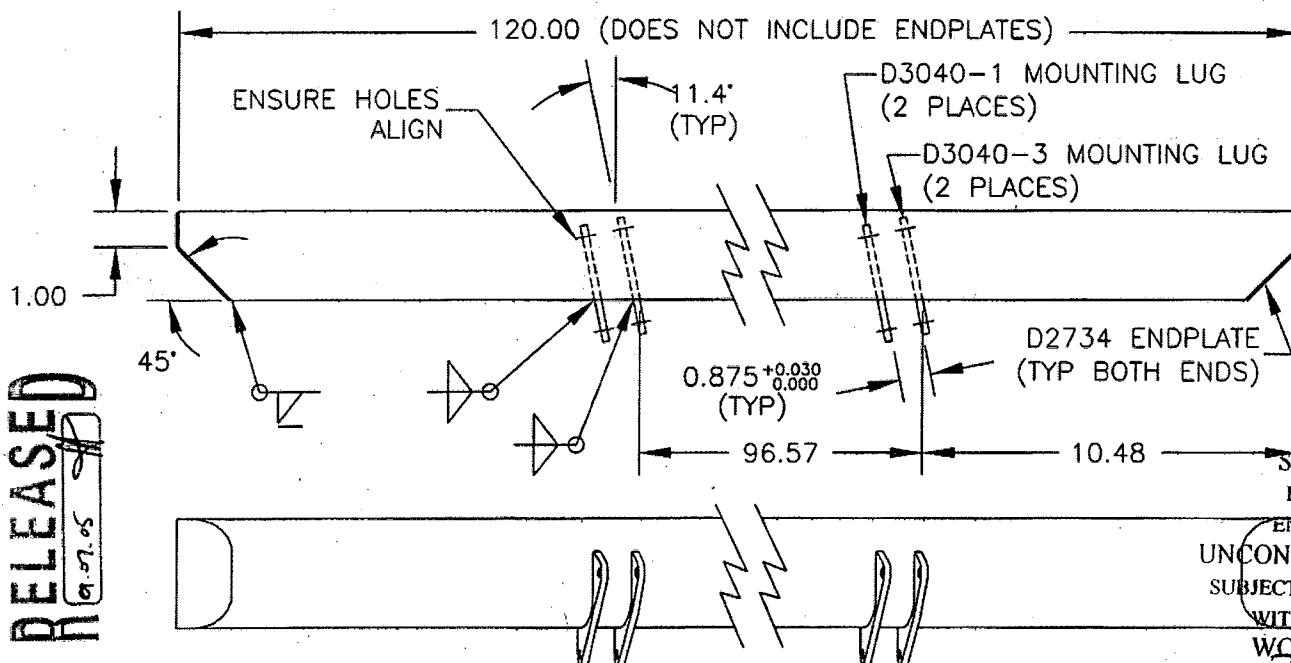
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| CHECKED # | APPROVED # | DRAWING NO. D3043 | REV. A SHEET 2 OF 2 |
| DATE 01.06.28 | | TITLE A119 STEP WELDMENT | SCALE 1:5 |
| A | 01.06.28 | NEW ISSUE | |



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

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